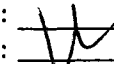
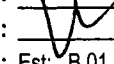


Date: Thursday, 10/08/2006 10:02:17 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR
Job Number : 28138	
Estimate Number : 11968	
P.O. Number : N/A	Part Number : D2061
This Issue : 10/08/2006 S.O. No. : N/A	Drawing Number : D2061 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : 	Due Date : 05/09/2006 Qty: 25 Um: Each
Checked & Approved By : 	
Comment : Est: B 01.12.17 Added step 3, 4 and Inspection Level 21. SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: 1809

Make per Dwg D2061

Possible Supplier: Sieg's Manufacturing

Material release note required

C206108110

(25)

2.0

D2061P

Aspirator



Comment: Qty.: 1.0000 Each(s)/Unit Total: 25.0000 Each(s)
 ASPIRATOR BODY

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

PU 6/9/01 (25)

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

2060815 25

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr and clean to remove was residue

FF 06.09.20 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *Q* Date: 06/09/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:02:17 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 28138

Part Number: D2061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

06/09/20

25

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

SB

06/09/20

55

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB

06/09/20

(05)

Job Completion



U 06/09/20

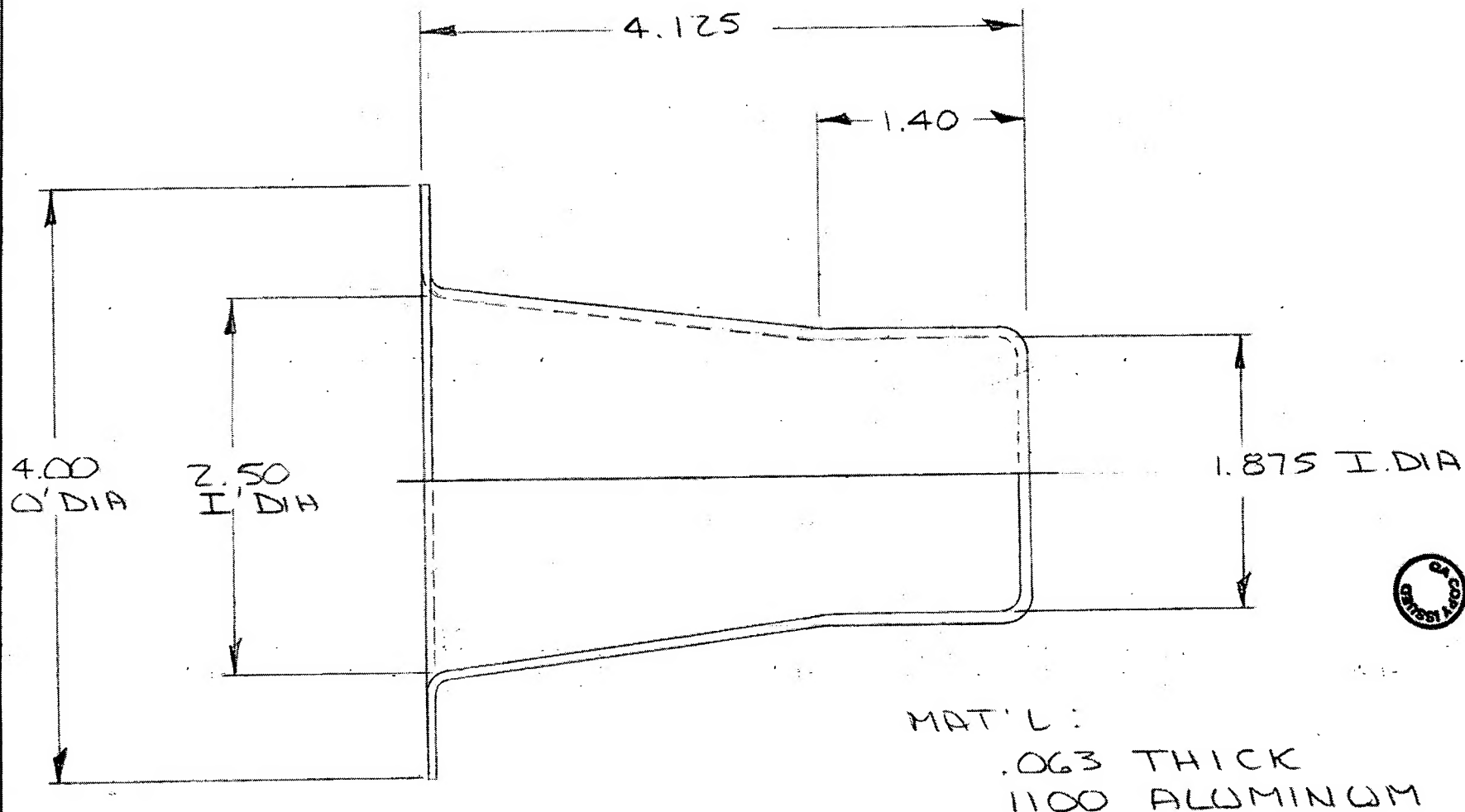
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 623	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE	DIA. DASH NO.	CONTRACT NO.	DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			D=CHAMFER O=OUTLINE OF SHEETS C=COUNTERSINK	W=SPOTWELD	DATE			
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL LIMITS 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH — S — 2742 5. HOLES PER AND 10387		BASIC CODES 8J=MS20470AD 88=MS20478AD		DRAWN DESIGN CHECKED CURT	TITLE ASPIRATOR BODY CODE DWG NO. YSD 2061 SCALE 1:1 SFT 1 OF 1		
REPORT ALL DISCREPANCIES — DO NOT SCALE								

YSD 2061

A



Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490

6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

INSPECTION REPORT

DATE: Aug. 25/06

CUSTOMER: Dart Aerospace

INVOICE #: _____ SUPPLIER #: _____

DESCRIPTION OF INSPECTION: _____

PART #	QTY.	MATERIAL	CHECK HOLES	DEBUR EDGES	INSP BY.
D2061P	25	.063 1100	N/A	✓	Kale

NOTES OF INSPECTION: Good.

NOTES OF REJECT: _____

Certification of Test Results

SOLD TO:
KENT-MAC METALS INC
2 THYSSEN DRIVE
DETROIT, MI 48210

TO BE ADVISED
PA

OLD PHS

PO 811326

CERT NO 0000043817
DATE 7/01/1998
SKID NO 631706
SKID WGT 9,560
PAGE 1 OF 1

ORDER NO	055535	PO NO	71993-D
ITEM NO	1	PART NO	
ALLOY	1100	TEMPER	O
GAUGE	06380	WIDTH	40.0000
		FORM	COIL
		LENGTH	.0000

MILL FINISH
NON ANODIZE QUALITY
OUT: STANDARD MILL FINISH
IN: STANDARD MILL FINISH
NOT EMBOSSED

LOT: 004297 COIL: B01

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
*B025571	0.12	0.47	0.13	0.003	0.008	0.000	0.003	0.002	0.01

HEAD ULTIMATE STRENGTH 13.8 KSI
TAIL ULTIMATE STRENGTH 13.9 KSI
HEAD YIELD STRENGTH 5.5 KSI
TAIL YIELD STRENGTH 5.2 KSI
HEAD ELONGATION 30.5 %
TAIL ELONGATION 30.5 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B557

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
QQA 250/1P 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

Date 12-11-98
Cust. Zussman Inc.
W/O # 483804
Qty. 3093 Pcs
These test reports are for material shipped
on your PO# 2115
From Copper & Brass Sales Inc.
Quality Representative
Customer Part #